

AMENDMENTS TO ABSTRACT

~~This invention mainly develops the multiple~~ A discharge-servo curve control method and device ~~of for an electrical discharge machine enables multiple discharge-servo curves to be chosen during a machining process in real-time. It comprises~~ The control device includes a storage unit, a setting unit, a reading unit, a program unit and an instruction-judging unit capable of swapping control curves during execution of the program whenever a discharge-servo curve instruction is encountered. ~~Herein the operator can dominate the program execution by using program calling method, and calls a discharge-servo curve instruction to satisfy with the real machining requirement. In order to achieve one-step processing with selectable multiple discharge-servo curve, this will swaps the discharge-servo curve from a system calling to a program calling.~~